Quality Control

# Work Order ID 101139

Wednesday, May 01, 2013 3:02:30 PM

\*101139\*

ASAP

Page 1

Revision ID:	03224-1 Frame		Accept	*N900	<u>040</u>	100	<b>)</b> * s	Setup Sta	. 13	S1* S2*
Start Date: 5 Required Date: 5 Reference:	5/1/2013 Start Qty F/2/2013 Req'd Qt	` <i>'</i>		Cust Item I Customer:	ID:				IV	. 17
	Process Plan:	Date: りょり. Date:	Tooling: SPC (Y/N):		ate: ate:		R	Run Sta Sto	" <b> </b> \	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									•
D3224	Rev B			·						
*100 *100* Waterjet FLOW CNC Waterjet 2024,063	,	FER JET  Memo  I-Cut as per Dwg D3224  Dwg Rev:	0.00				3.	<b>&amp;</b>		Jn13.5-2
*110 *110* QC		t parts off machine FAI/FAIB	0.00			,	3	۵		Jm13-5-2

NICD.	V	,	NI.
NCR:	Yes	1	No

### **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA:	Date	·

NCN. 1	.es / NO				WORK ORDER HOR-C		MINIMOL / C	JI DATE	QA Closed:	Date:	:
Work Orde	er:	1	·		DISPOSITION			AGAINST DI	EPARTMENT	/PROCESS	
Part N	-				Rework Scrap	71	Skid-tube Machining	Crosstube Small Fab	<b>-</b> i	Water Jet	Engineering Quality Other
NCR N	lo	:		<u> </u>	Use-as-is Work Order Update	]   Ine	ermoforming Large Fab	Finishing Composite	_ KeC/Sto	re/Packaging Supplier	- Other
Root				Descri	ption of work order update	Initia		Action	Sign &	1	·
Cause	Date	Step	Qty	C	or Non-conformance	Chief E	ng De	escription	Date	Verification	QC Inspector
Doc/Data						1	·				
Equip/Tooling						1	1	•		1	
Operator							1			ł	
Material							1 .				
Setup											
Other	_									,	
Process		:									
Supplier											
Training											
Unapproved		<u> </u>	<u>l 1</u> .			4.	TECODY		1	1	<u> </u>
						AULT CA	TEGORY				
Landir	ng Gear	÷			General	Grai	_	Г	Ovalized		Pressure/Forced
	Bending			, <sub>c</sub>	Bend	<del></del>		<del> </del>	Over/Under	tolorance	Temperature/Cure
	Centre N	ot Concei	ntric to O	/ <sup>s</sup>  -	BOM/Route	$\boldsymbol{\vdash}$	ware	_	Part Incorre	· -	Weld
	Cracks	Cuina		$\vdash$	Broken/Damaged	<del></del>	ection Incomplete uctions Incomple	<del>-</del>	Part Lost/M	<del></del>	Wrong Stock Pulled
	Crushed/ Cuffs	Crimpea		$\vdash$	Burrs Contamination	<b>⊢</b>	uctions incomple ntenance	-te/onclear	Part Moved	Ţ <b>—</b>	JWrong Stock Fulled
	_			-	Countersink	$\vdash$	abeled	-	Positioned \	1	
	Heat Trea		Tubo	$\vdash$	Cut Too Short	Misr		<del> </del>	Power Loss		Other
	Ripples in	:	i iube	$\vdash$	Drill Holes	Offse		<b>L</b>	J. 0WEI 1033/	Juige	Tourier.
	Torque V	1	Evtrucion	<u> </u>	Drawing	$\blacksquare$	of Calibration				
	Turning S			-	Finish	-	of Sequence			· · · · · · · · · · · · · · · · · · ·	
	Wave/Tv			$\vdash$	Folio	$\vdash$	ide Dimensions		<del></del>	1	
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## \*101139\*

Work Order ID 101139

Wednesday, May 01, 2013 3:02:30 PM

Item ID:

D3224-1

**Revision ID:** 

Item Name: Frame

Required Date: 5/2/2013

**Start Date:** 

5/1/2013

QC:

Start Qty: 6.00

Req'd Qty: 6.00

Accept

\*N900040100\*

Setup Start

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Sequence ID/ Work Center ID

120

\*120\* QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

130

\*130\* Small Fab

Small Fab

Small Fab

Memo Deburr 0.00

0.00

140

\*140\* Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3224

0.00

0.00

		I			•					DO	A:	Date	! <b>:</b>	
NCR:	Yes / No	÷			WORK ORDER NON-C	O	VFOR	MANCE / UP	DATE	OA Class	- . اد.	Data		
					1					QA Close	2a:	Date	<u>:</u>	<del></del>
Work Orde	eŕ:	:			DISPOSITION				AGAINST DE	PARTME	NT/I	PROCESS		
Part No.  NCR No.  Root Descri							Crosstube Small Fab Finishing Composite	-1		Water Jet Eng. Coor. P/Packaging Supplier		Engineering Quality Other		
Root		T		Descri	ption of work order update	ı	nitial	Act	tion	Sign &			T	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date		Verification		QC Inspector
Doc/Data													$\top$	
Equip/Tooling		·									Ì			
Operator			]											
Material														
Setup		1 :												
Other		'.									ĺ			
Process						۱.						1		
Supplier														
Training					·		, 5					,		
Unapproved		i					41 J						丄	
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Landi	ng Gear				General		_			_			_	
	Bending				Bend		Grain			Ovalized		L	Pr	ressure/Forced
	Centre N	lot Conce	ntric to (	o/s	BOM/Route		Hardwa	ire		Over/Und	ier t	olerance	JT€	emperature/Cure
				Broken/Damaged	Inspection Incomplete			Part Inco	rrect	:	_]w	/eld		

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Work Order ID 101139 \*101139\* Page 3 Wednesday, May 01, 2013 3:02:30 PM D3224-1 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Frame **Start Date:** 5/1/2013 Start Qty: 6.00 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 5/2/2013 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Oty Number Stamp 150 QC5- Inspect part completeness to step on W/O 0.00 **@**3 \*150\* QC Memo 1353 Quality Control 160 Chemical Conversion Coat per QSI005 4.1 0.00 16,135 B \*160\* HandFinish 0.00 Memo Hand Finishing

170

\*17**0**\*

Quality Control

QC7-Inspect Chemical Conversion Coat

Memo

										DQA.	Date	
NCR: Y	es / No	1			WORK ORDER NON-C	CONF	ORN	MANCE / UPDATE		QA Closed:	Date	
		1			T					QA Closed:	Date	
Work Orde	er:	1			DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	
		:			Rework	7 l		Skid-tube Cross	tube	1	Water Jet	Engineering
Part N	lo.	•			Scrap	1	ſ	Machining Smal	l Fab	Pro	d. Eng. Coor.	Quality
	<u></u>	:			Use-as-is	]   T	herm	noforming Finis	shing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab Comp	osite	]	Supplier	
		-	1 3				1				,	
Root			۵.		ption of work order update	Initi	- 1	Action		Sign &	Manifi andian	06 transatas
Cause	Date	Step	Qty	<del></del>	or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator												
Material Setup												
Other		'										
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upplier												
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Jnapproved												
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Landir	ng Gear			· ·	General					_		
	Bending				Bend	Gr	rain			Ovalized		Pressure/Forced
i	Centre N	lot Conce	ntric to	o/s	BOM/Route	На	irdwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks	1			Broken/Damaged		· .	on incomplete		Part Incorred	<u> </u>	Weld
		/Crimped			Burrs	-		ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	1			Contamination	$\vdash$		nance	_	Part Moved		
	Heat Tre			<u> </u>	Countersink	$\vdash$	islabe		_	Positioned V	_	<b>¬</b> .
		on Strip in	Tube	<u></u>	Cut Too Short	$\vdash$	isread	1		Power Loss/	Surge	Other
	Ripples in Bend				Drill Holes	$\mathbf{H}$	fset					<u> </u>
	Torque V	Vaves in E	Extrusio	n	Drawing	Ou	ut of C	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Finish

\*190\*

Quality Control

QC

Wednesday, May 01, 2013 3:02:30 PM

Item ID: D3224-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Frame Start Qty: 6.00 **Start Date:** 5/1/2013 **Cust Item ID:** Required Date: 5/2/2013 Req'd Qty: 6.00 **Customer:** Reference: Run **Approvals: Process Plan:** Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. **Work Center ID Description** Qty Qty Number Stamp Run Hours Code 180 Identify as per dwg & Stock Location: 0.00 \*180\* 51218 Packaging 0.00 Memo Packaging 190 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

13/5/6 TO)

										DQA:	Date	2
NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	VANCE / UPDATE		QA Closed:	Date	•
Work Orde	ř·				DISPOSITION			AGAINST	DE	PARTMENT		· · · · · · · · · · · · · · · · · · ·
Part N	o				Rework Scrap Use-as-is		herm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCR No Work Order Update Large Fab								Large Fab Composite	Щ.		Supplier	ا الــا
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Init Chief	1	Action Description		Sign & Date	Verification	QC Inspector
Ooc/Data quip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AULT C	ATE	GORY				
Landin	g Gear  Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Ha Ins Ins Mi Mi Of	struct ainte islabe isread fset	ion Incomplete ions Incomplete/Unclear enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

#### **Picklist Print**

Wednesday, May 01, 2013 3:02:29 PM

Work Order ID:

101139

Parent Item:

D3224-1

Parent Item Name:

Frame

**Start Date:** 5/1/2013

Required Date: 5/2/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 05-11-06 JLM

IPP: B 06.11.15 waterjet

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M2024T3S.063</b> 2024-T3 .063 sheet		Purchased	No			100	sf	219.8800	5.2	32.84210	16		Jm13-5-2

Location	Loc Qty	Loc Code	
MAT022	219.88		
119916	0.2		
121197	21.34		
123096	11.4		
123654	11.64		
123701	79.3		123701
125341	96		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,

Page 1

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NCR: Y	'es /	No	:			WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE	OA Classed	0-1-	
						T					QA Closed	: Date	-
Work Orde	è.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo					Scrap Machining Small Fab			Crosstube Small Fab Finishing	-4	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
IVCK IV			1			Work Order opuate	J		carge rab	Composite[	1	- Subblief [	
Root Cause	,	Date	Step	Qty		ption of work order update	ŀ	Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data	+	-	Jiep			or trott comornate	J	28			1		
Equip/Tooling				:			1						
Operator									÷		1		
Material												'	
Setup											]		
Other			:										
Process			ı				l						
Supplier			:								-		
Training							1						
Unapproved			:										
						F.	AUL	T CATE	GORY				_
Landir	ng Gea	r	1			General	_	-			٦	_	_
	Be	nding	1			Bend	<u>_</u>	Grain			Ovalized	_ · _  _	Pressure/Forced
	Ce	ntre No	ot Concer	ntric to (	D/S	BOM/Route	L	Hardwa		<u> </u>	Over/Under	<del>-</del>	Temperature/Cure
		acks			_	Broken/Damaged		-4 `	on incomplete	_	Part Incorre	<u> </u>	Weld
	Cr	ushed/0	Crimped			Burrs		-1	ions Incomplete/	Unclear	Part Lost/N		Wrong Stock Pulled
	Cu		:			Contamination	<u></u>	Mainte		<u> </u>	Part Moved		
		at Trea				Countersink		Mislabe			Positioned '		<b>-</b> 7 .
	Inspection Strip in Tube Cut Too Short					Misread			Power Loss	/Surge	Other		
	Ripples in Bend Drill Holes					Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

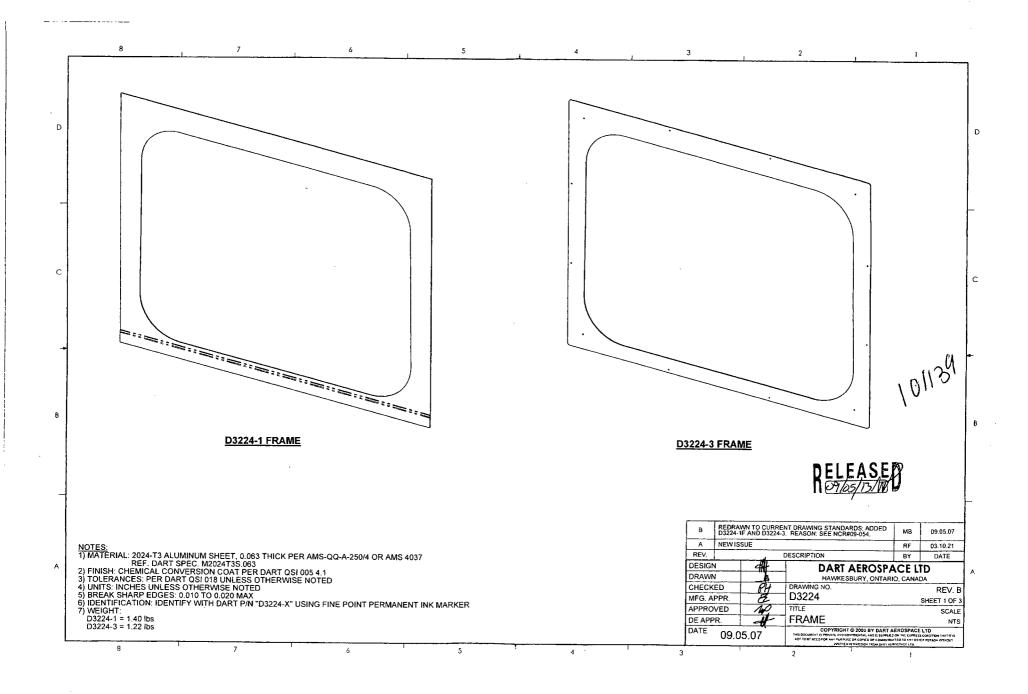
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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		1								DQA:	Date:	
NCR: Y	es / No	1			WORK ORDER NON-	CO	NFOR	MANCE / UPDATE				
	-	:			<del></del>					QA Closed:	Date:	
Work Orde	or.	:			DISPOSITION			AG	AINST DE	PARTMENT	/PROCESS	
WOIK OIGC		1			Rework	7		Skid-tube Cro	sstube	1 ·	Water Jet	Engineering
Part N	lo.				Scrap	1		<b>⊢</b>	all Fab	Pro	d. Eng. Coor.	Quality
		- * * +			Use-as-is		Thern	noforming Fir	nishing	Rec/Sto	re/Packaging	Other
NCR N	lo	·	-		Work Order Update	]		Large Fab Com	posite	]	Supplier	
Root				Descri	ption of work order update	Τ	Initial	Action		Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ct	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data		1	1 1									
Equip/Tooling											. i	
Operator		į										-
Material		1 :										
Setup											1	
Other			] ]	•								·
Process												
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Training												
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		1				AUI	LT CATE	GORY				
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. [	Bending	1			Bend	L	Grain			Ovalized		Pressure/Forced
	· Centre N	lot Conce	ntric to (	o/s	BOM/Route	L	Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct [	Weld
	Crushed	/Crimped	<b>├</b> ─┤ ` `				Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	:	Contamination				Mainte	nance		Part Moved		
	Heat Tre	at	Countersink				Mislabeled			Positioned V	Vrong	_
	Inspection	Inspection Strip in Tube Cut Too Short					Misread Power Loss/Surge Other			Other		
	Ripples i	n Bend	· —									

Out of Calibration

Out of Sequence

Outside Dimensions

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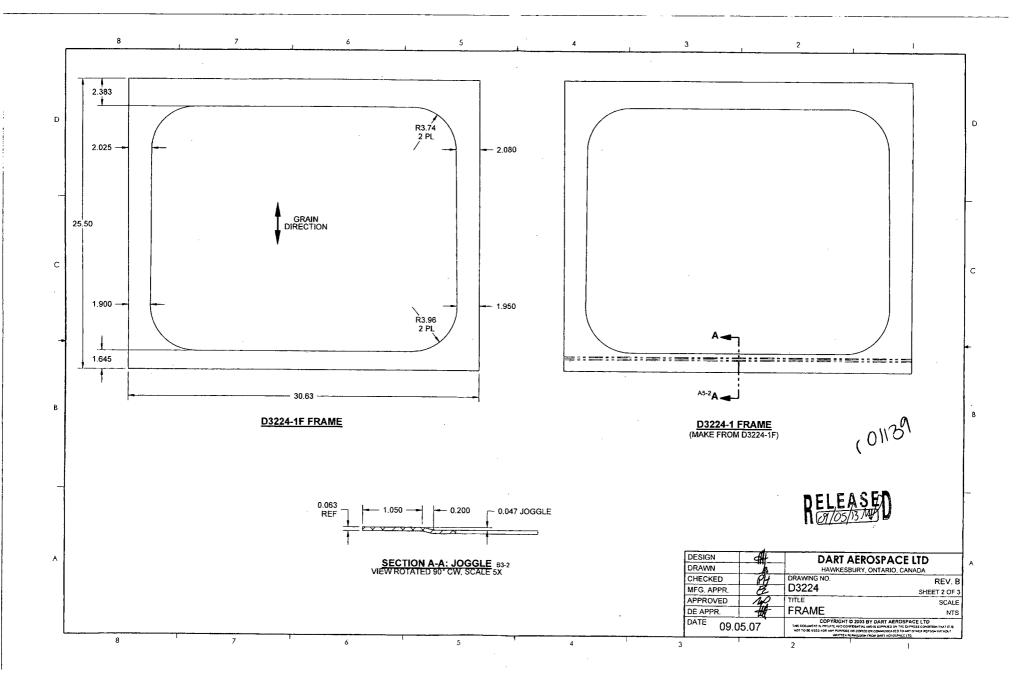
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

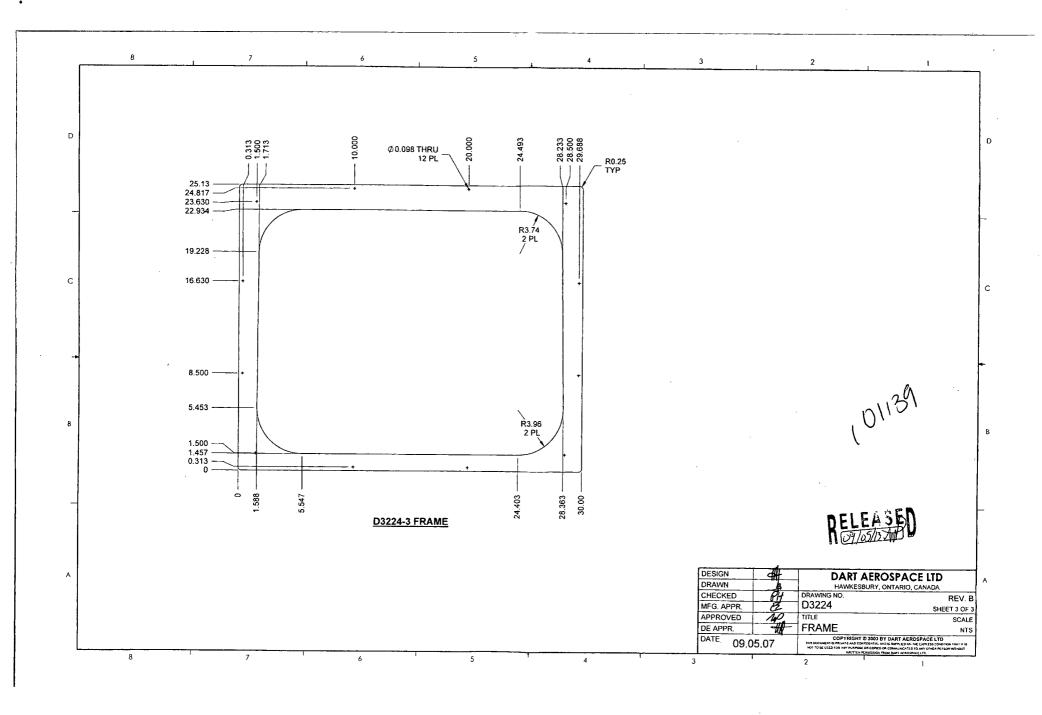
Finish



NCR:	Yes / No	:	WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	·	Date:	
	· · · · · ·		

			;	•							QA Closed:	Dat	te:
Work Orde	er:		1			DISPOSITION			•	AGAINST DE	PARTMENT	/PROCESS	
Part N	– No					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
										1			
Root			:		Descri	ption of work order update	1	nitial	•	ction	Sign &	•	
Cause		Date	Step	Qty	,	or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data			:									,	
Equip/Tooling	Ш											:	
Operator	Ц		'										
Material	Ц												
Setup													
Other			:									1	
Process	Ш											1	
Supplier	Н											٠	
Training	Н		T f									'	·
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1			<del>.</del>				AUL	CATE	GURT		- <u></u>		
Landii		ending	1		Г	General Bend		Grain			Ovalized		Pressure/Forced
	—	_	ot Concer	atric to	0/s	BOM/Route	-	Hardwa	ro.	<del> </del>	Over/Under	tolerance	Temperature/Cure
	—	racks	Conce	iti ic to	°′3	Broken/Damaged	$\vdash$		ion Incomplete		Part incorre	·	Weld
	${f H}$	rushed/0	Crimned		<u> </u>	Burrs	$\vdash$	•	ions Incomplete	/Unclear	Part Lost/Mi		Wrong Stock Pulled
	⊢	uffs	crimpea.		<u> </u>	Contamination	-		enance		Part Moved	,	
		leat Trea	ıt		.	Countersink		Mislabe		-	Positioned V	Vrong	
	<del></del> 1		n Strip in	Tube	<u> </u>	Cut Too Short	$\vdash$	Misread		<u> </u>	Power Loss/	- 1	Other
	$\blacksquare$	lipples in				Drill Holes	$\vdash$	Offset		<b>L_</b>	_		
	-		aves in E	xtrusio	n	Drawing	-		Calibration				
	$\boldsymbol{\vdash}$	-	equence			Finish	П	Out of S	Sequence			,	
	$\boldsymbol{\vdash}$		ist in Tul			Folio	П	Outside	Dimensions				



							DQA:	Date	•
NCR: Yes /	No			WORK ORDER NON-C	CONFORI	MANCE / UPDATE	QA Closed:	Date	
Work Order:				DISPOSITION		AGAINST	DEPARTMENT	<b>-</b>	
Part No						Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	Pro- Rec/Stor	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause Da	ite Step	Qty		ption of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier raining napproved			į.						
				F/	AULT CATE	GORY			
Crac Crus Cuff Hea Insp Ripp	re Not Conce ks hed/Crimped s : Treat ection Strip in les in Bend que Waves in	i n Tube Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instruct Mainte Mislabe Misrea Offset Out of	ion Incomplete ions Incomplete/Unclear enance eled d	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
<del></del>	ing Sequence e/Twist in Tu		-	Finish Folio	$\vdash$	Sequence 2 Dimensions			

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DART AEROSPACE LTD	Work Order:	101139		
Description: Frame	Part Number:	D3224-1		
Inspection Dwg: D3224 Rev: B		Page 1 of 1		

#### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
25.50	+/-0.030	25.50"	-		T	Jkmalo
30.63	+/-0.030	30.63	_		T	
1.900	+/-0.010	1.904"	_		V	Jamos
2.025	+/-0.010	2.030	_		ν	
1.645	+/-0.010	1.650"	_		V	
1.950	+/-0.010	1.953"	_		ν	
2.080	+/-0.010	7.080	-		ν	
0.063	+/-0.010	0.061	-		ν	
2.383	+/-0.010	2.385"	_		ν	
_	•					
						****
	•		041			

Measured by: Jm	Audited by: 27	Preliminary Approval:
Date: 13-5-2	Date: 1352	Date:

Rev	Date	Change	Revised b	у	Approved
Α	04.10.05	New Issue P/O D412-709-011	KJ/JLM (	1	to the
В	11.03.08	Dimensions updated per Dwg Rev B	KJ %	1	И
· <del></del>			7	$\mathcal{T}$	

NCR: Yes / No	NCR:	Yes	/	No
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· / No			WORK ORDER NON-C	ONFORI	MANCE / UPDATE		DQA:	Date:	· · · · ·
		•	DISPOSITION		AGA			Date:	
o			Rework Scrap Use-as-is Work Order Update		Machining Sma	II Fab		<del></del>	Engineering Quality Other
			Description of work order update	Initial	Action		Sign &	:	
Date	Step	Qty	or Non-conformance	Chief Eng	Description		Date	Verification	QC Inspector
		4 · K							
				ULI CATE	GORY	•			
Bending Centre N Cracks Crushed/ Cuffs Heat Tre Inspectio Ripples in Torque V	/Crimped at on Strip in n Bend Vaves in I Sequence	Tube Extrusion	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Inspection Instruct Mainte Mislabe Misread Offset Out of S	ion Incomplete ions Incomplete/Unclear enance eled d Calibration Sequence		Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W	tolerance :: ssing :: /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled  Other
	Date  Bending Centre N Cracks Crushed/ Cuffs Heat Tre Inspectic Ripples in Torque V Turning S	Date Step  Gear Bending Centre Not Conce Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in I	Date Step Qty  Gear Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	DISPOSITION  Rework   Scrap   Use-as-is   Work Order Update    Date   Step   Qty   Description of work order update   or Non-conformance    Gear   General   Bend   BoM/Route   Broken/Damaged   Broken/Damaged   Burrs   Custed/Crimped   Burrs   Contamination   Cuffs   Contamination   Con	DISPOSITION  Rework   Scrap   Use-as-is   Work Order Update   Initial   Chief Eng    Date   Step   Qty   Or Non-conformance   Chief Eng    Step   General   Bend   Grain   General   Gener	DISPOSITION   Rework   Skid-tube   Cros   Smachining   Smachining   Composition   Chief Eng   Chief Eng	DISPOSITION   Rework   Skid-tube   Crosstube   Machining   Small Fab   Large Fab   Composite	No   WORK ORDER NON-CONFORMANCE   UPDATE	No   WORK ORDER NON-CONFORMANCE   UPDATE   QA Closed: Date:   Disposition   Disposition   Rework   Scrap   Use-as-is   Work Order Update   Use-as-is   Work Order Update   Use-as-is   Verification   Composite   Use-as-is   Verification   Composite   Use-as-is   Verification   Composite   Use-as-is   Verification   Veri